

# Work Order ID 63259

October 27, 2010 8:39:13 AM



Page 1

Item ID: D3296-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Door Assembly

Start Date: 10/27/10 Start Qty: 6.00



Cust Item ID:

Required Date: 10/28/10 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3296

Rev A

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Fabricate & assemble as per Dwg D3296.

Transfer drill using DT8470 & DT9521

*Ep 10/28* (6)

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

*Sc 10/28*

(46)

120

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 9:05 OVEN TEMPERATURE:

320° FINISH TIME:

9:35

*M 112 588*

*6* *10/11-1*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 63259

October 27, 2010 8:39:14 AM

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Item ID: D3296-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Door Assembly

Start Date: 10/27/10 Start Qty: 6.00

Cust Item ID:

Required Date: 10/28/10 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start

QC: Date: SPC (Y/N): Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

7 261 10/11/01 6 0

140

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg D3296

Ep 10/11/01 @ 6

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Solulor

(x6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Work Order ID 63259

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Item ID: D3296-041

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Setup Start



Revision ID:

Stop



Item Name: Door Assembly

Start Date: 10/27/10 Start Qty: 6.00



Cust Item ID:

Required Date: 10/28/10 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  Packaging Packaging	Identify as per dwg & Stock Location: <u>218</u>  Memo	0.00  0.00							<u>10/11/45</u> 
170  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00							<u>10/11/05</u>   <u>MF</u> <u>10-11-4</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

October 27, 2010 8:39:12 AM

Page 1

Work Order ID: 63259

Parent Item: D3296-041

Parent Item Name: Door Assembly

Start Date: 10/27/10

Required Date: 10/28/10

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP C005.10.14 Added step 14 KJ/ECU  
IPP Rev:D Revised Steps 06-11-20 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

\* AN960JD6

NAS1149DN632 Purchased

No

140

Each

444.0000

1

6



Washer

4 M112794 (6x)



EP 10/10/27

Location

Loc Qty

Loc Code

ST347

444

104537

444

D2137

Manufactured

No

140

Each

18.0000

1

6



Decal - No Step



EP 10/10/27

Location

Loc Qty

Loc Code

ST006

18

59395

8

62071

10

D2419

Manufactured

No

140

Each

6.0000

1

6



Handle



EP 10/10/27

Location

Loc Qty

Loc Code

ST014

6

61223

6

D2462

Manufactured

No

140

f

605.6007

0.3333

1.9998



Seal



EP 10/10/27

Location

Loc Qty

Loc Code

ST404

605.6007

48530

605.6007

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries



# Picklist Print

Page 2

October 27, 2010 8:39:12 AM

Work Order ID: 63259

Parent Item: D3296-041

Parent Item Name: Door Assembly

Start Date: 10/27/10

Required Date: 10/28/10

Start Qty: 6.00

Required Qty: 6.00



Dart Logo label



Hinge 14.0"



Hinge 17.0"

Manufactured No

140 Each 0.0000 0 0

Manufactured No

100 Each 0.0000 1 6

Manufactured No

100 Each 6.0000 1 6

Location

Loc Qty

Loc Code

ST040

6

53228

6

Manufactured No

100 Each 7.0000 1 6

Location

Loc Qty

Loc Code

ST186

7

57975

7

Manufactured No

100 Each 16.0000 1 6

Location

Loc Qty

Loc Code

ST186

16

59639

16



Door Panel



Door Panel

October 27, 2010 8:39:12 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

October 27, 2010 8:39:12 AM

Work Order ID: 63259

Parent Item: D3296-041

Parent Item Name: Door Assembly

Start Date: 10/27/10

Required Date: 10/28/10

Start Qty: 6.00

Required Qty: 6.00

MS20470AD4-4

Purchased

No

140

Each

2,288.000

25

150



Rivet, Universal Head



*EP 10/10/27*

Location

Loc Qty

Loc Code

ST319

2288

112314

30

113368

92

115470

2166

*150*

MS20470AD4-6

Purchased

No

100

Each

1,211.000

1

6



Rivet, Universal Head



*EP 10/10/27*

Location

Loc Qty

Loc Code

ST320

1211

114905

152

114988

1059

*6*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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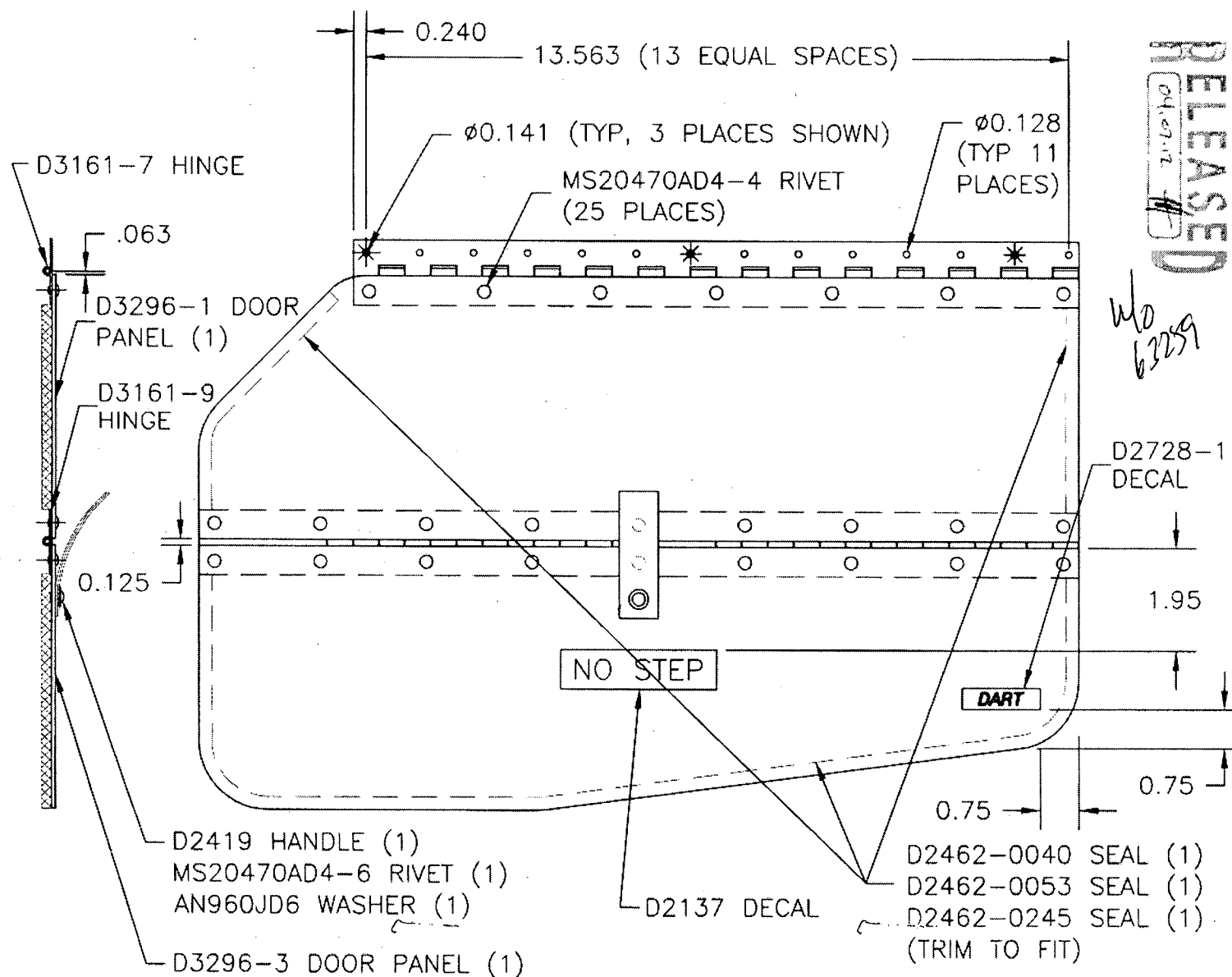
**DART**



DESIGN	W/P	DRAWN BY	W/P	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D3296
DATE	04.06.28	TITLE	DOOR ASSEMBLY	REV. A 1 OF 2
A	04.06.28	NEW ISSUE		SCALE 1:3

RELEASED  
04.07.12

W/P  
63259



# D3296-041 DOOR ASSEMBLY

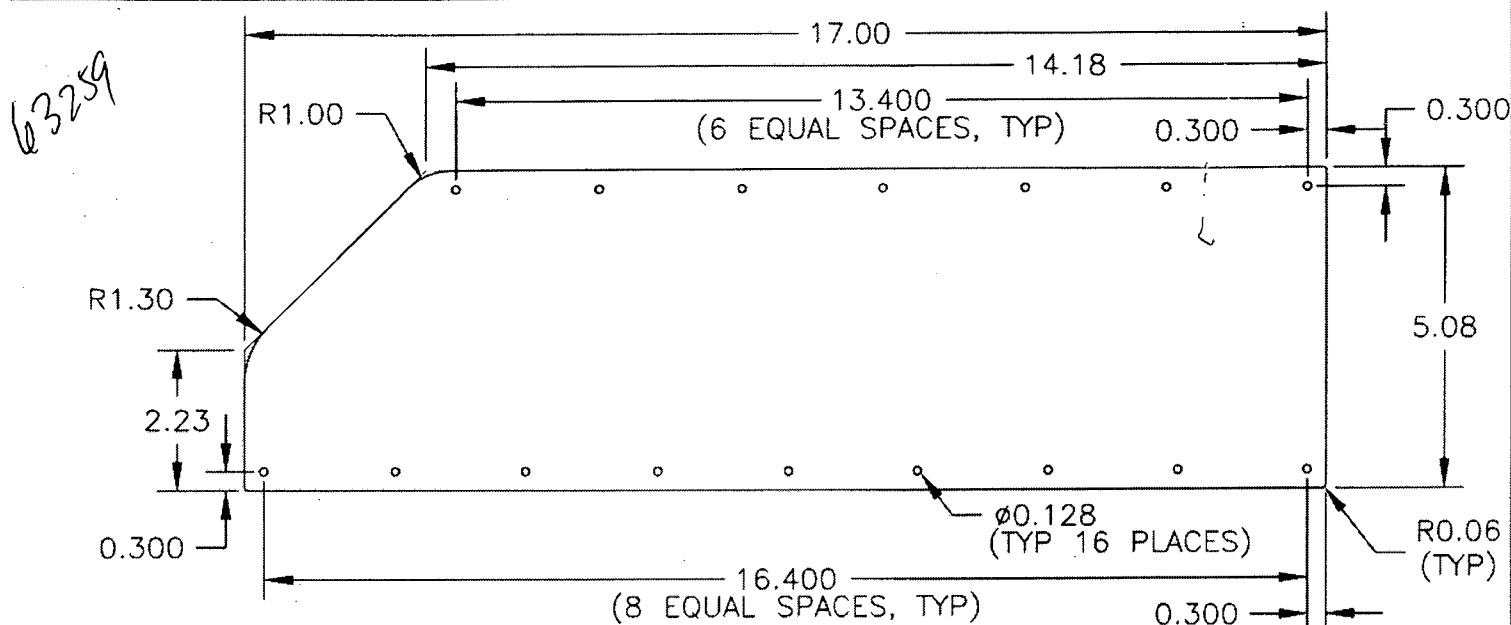
- 1) FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) INSTALL D2137 & D2728-1 DECALS, D2419 HANDLE, AND D2462 SEALS AFTER POWDER COAT
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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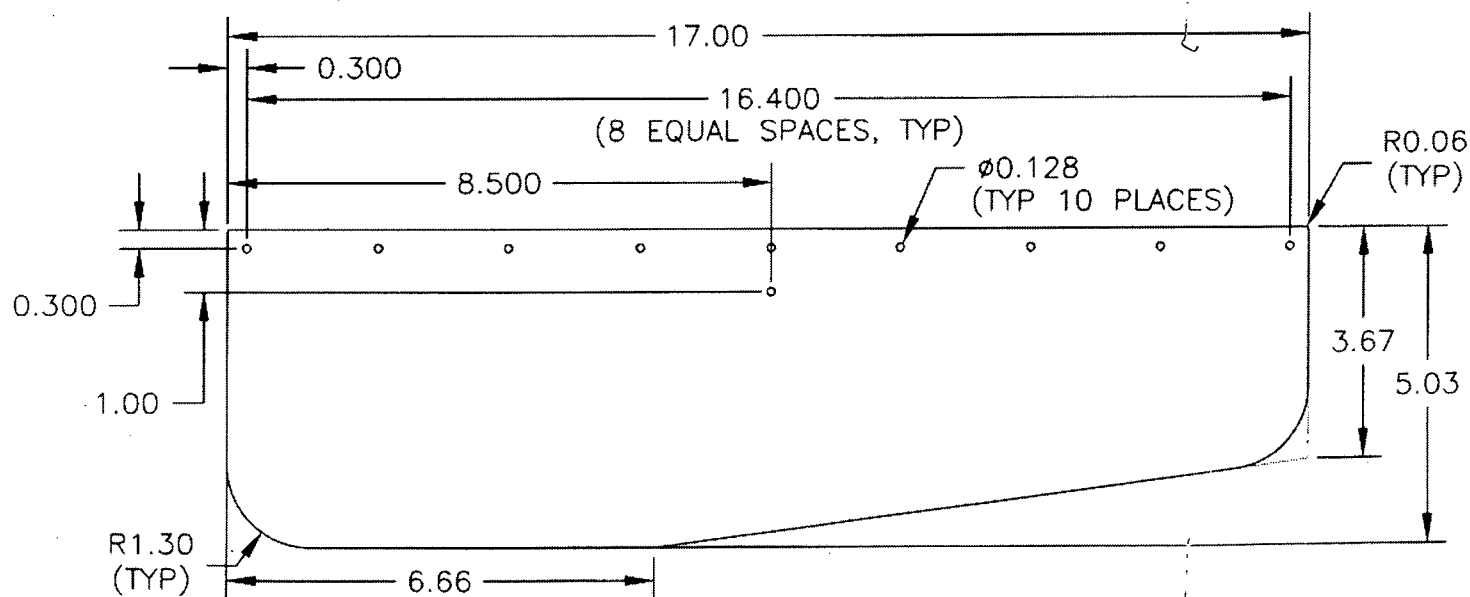
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CHECKED <i>HH</i>	APPROVED <i>HH</i>	DRAWING NO. D3296	REV. A 2 OF 2
DATE 04.06.28		TITLE DOOR ASSEMBLY	SCALE 1:3



**D3296-1 DOOR PANEL**



**D3296-3 DOOR PANEL**

**D3296-1 AND D3296-3**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK  
(REF DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED  
04.07.12

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